

Work Order ID 83435

83435

Page 1

April-18-12 8:16:10 AM

Item ID: D2888

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lug

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/18

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2888

Rev A2

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks at 4.200" long
Grain along 4.200"*

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio D2888

Folio Rev: A2

Dwg Rev: A

2-Deburr

Fk 12/06/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150 Powdercoat Powder Coating									
	Memo START TIME: 10:00 OVEN TEMPERATURE: 320 °F FINISH TIME: 10:30	0.00				12X	✓		M.F. 12/06/08
160	QC3- Inspect Part Finish	0.00							
160 QC Quality Control									
	Memo	0.00				12	✓		12/06/11
170	Identify as per dwg & Stock Location 51485	0.00							
170 Packaging Packaging									
	Memo	0.00				12		500	12/06/11

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Revision ID:

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Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 12.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/6/11 *[Signature]**MF*
12-06-11

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Picklist Print

April-18-12 8:16:14 AM

Page 1

Work Order ID: 83435

83435

Parent Item: D2888

D2888

Parent Item Name: Lug

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	15.7500	0.39	4.68			

M6061T6B2 500X03 500

6061-T6 Bar 2.50 x 3.50

**

PO 12/08/02

Location

Loc Qty

Loc Code

MAT004

12

→ 121070

12

MAT008

3.75

120708

3.75

4.68

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DART AEROSPACE LTD		Work Order:	83435
Description: Lug		Part Number:	D2888
Inspection Dwg: D2888	Rev: A2	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	.386	✓		FK-04	Vern.
Ø0.88	+/-0.030	.878	✓		"	"
0.063 x 45°	+/-0.010	.063 x 45°	✓		"	"
4.06	+/-0.030	4.06	✓		"	"
Ø0.760	+0.005/-0.000	.760	✓		"	"
3.48	+/-0.030	3.48	✓		"	"
2.500	+/-0.010	2.500	✓		"	"
2.75	+/-0.030	2.75	✓		"	"
0.438	+/-0.010	.438	✓		"	"
0.080 x 45°	+/-0.010	.080 x 45°	✓		"	"
1.85	+/-0.030	1.857	✓		"	"
1.000	+/-0.010	1.001	✓		"	"
0.425	+/-0.010	.428	✓		"	"
0.030 x 45°	+/-0.010	.030 x 45°	✓		"	"
1.875	+/-0.010	1.875	✓		"	"
0.375	+/-0.010	.375	✓		"	"
R0.25	+/-0.030	.25	✓		red gauge	
1.29	+/-0.030	1.287	✓		FK-04 Vern.	
0.414	+/-0.010	.414	✓		FK-06	Depth gauge
3.41	+/-0.030	3.392	✓		FK-04 Vern.	

Measured by: FK	Audited by: J.A	Prototype Approval:	N/A
Date: 12/06/05	Date: 12/06/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	

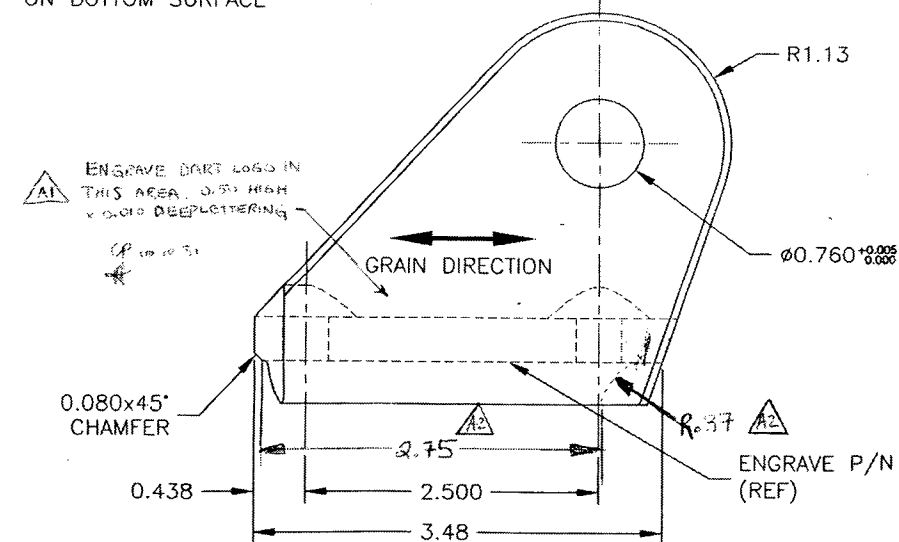
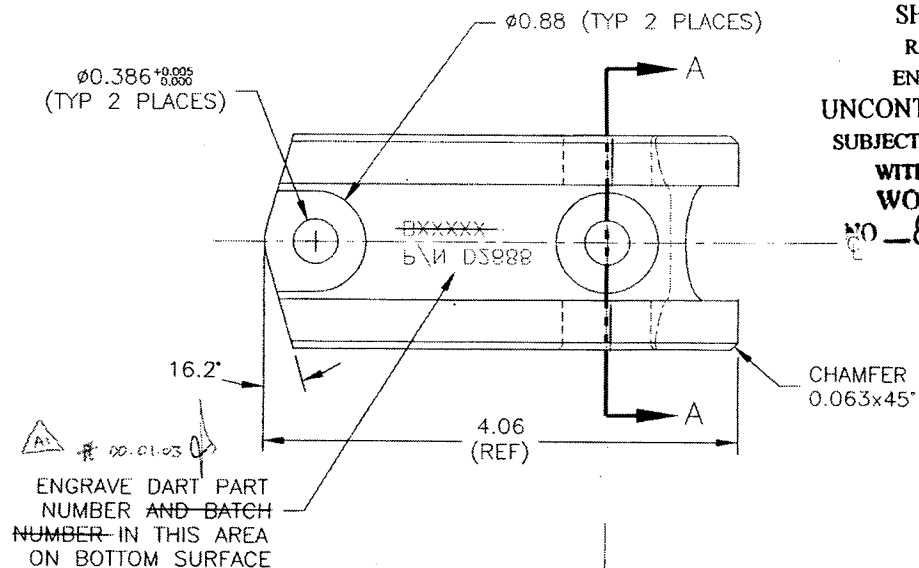
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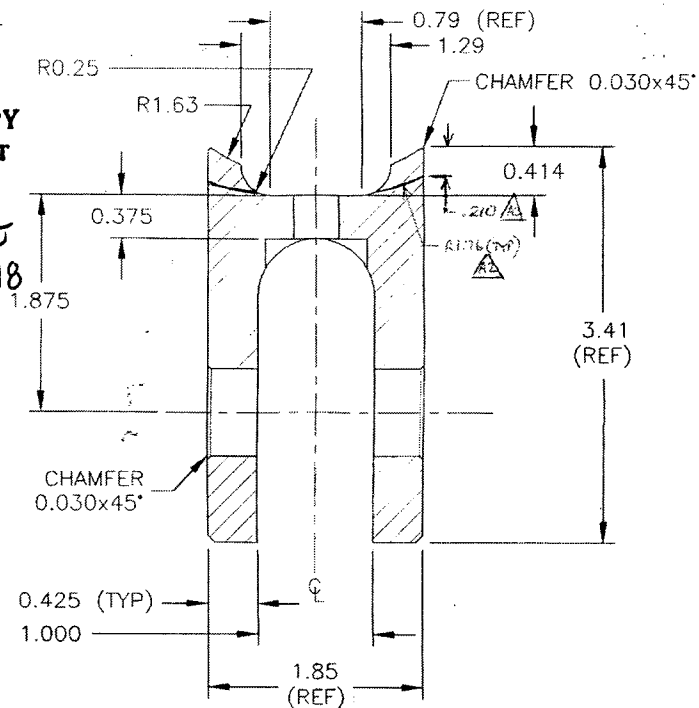
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 83435 MLJ
12/04/18



SECTION A-A
SCALE 1:1

RELEASED
99.01.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A	99.06.21	NEW ISSUE	
DESIGN	DRAWN BY	DART	DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2888	SHEET 1 OF 1
DATE	TITLE		SCALE
99.06.21	LUG		1:1

A2	04.04.08	Add Saddle Clearance for NCR 794	
A1	00.10.31	Update Engineering	

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